

Black

Work Order ID 119830

May-27-14 9:10:09 AM

\*119830\*

Page 1

Item ID: D2594-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Plug

Start Date: 5/26/14

Start Qty: 130.00

\*130\*

Cust Item ID:

Required Date: 5/26/14

Req'd Qty: 130.00

\*130\*

Customer:

Reference:

Approvals:

Process Plan:

u

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2594

Rev C

100

0.00

\*100\*

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262.2-Break all sharp edges 0.010 max.

130

Ø

DAS  
44  
9-89

14/05/29

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

130

Ø

DAS  
44  
9-89

14/05/29

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

130

Ø

14-5-29

DAS  
44  
9-89

# Work Order ID 119830

May-27-14 9:10:09 AM

\*119830\*

Page 2

Item ID: D2594-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Plug  
 Start Date: 5/26/14 Start Qty: 130.00 \*130\* Cust Item ID:  
 Required Date: 5/26/14 Req'd Qty: 130.00 \*130\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
*130*									
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss (Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*140*									
Powdercoat	Memo	0.00							
Powder Coating	BLACK SANDTEX B 126878- START TIME: 8:35 FINISH TIME: 9:05 OVEN TEMPERATURE: 320								
150	QC3- Inspect Part Finish	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

130 7/6/14-3-29

130 14-6-2. DAS 34 9-89

DAS  
16  
9-89 14/06/02

130  
cont

# Work Order ID 119830

May-27-14 9:10:09 AM

\*119830\*

Page 3

Item ID: D2594-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Plug

Start Date: 5/26/14

Start Qty: 130.00

\*130\*

Cust Item ID:

Required Date: 5/26/14

Req'd Qty: 130.00

\*130\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: FP-0d

0.00

\*160\*

Packaging

Memo

0.00

Packaging

x130 d H 40616-

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

0.00

Quality Control

MLJ 14-06-02

AA 14-06-02

# Picklist Print

May-27-14 9:10:08 AM

Page 1

Work Order ID: 119830

**\*119830\***

Parent Item: D2594-1

**\*D2594-1\***

Parent Item Name: Plug

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 130.00

Required Qty: 130.00

Comments: IPP D02.08.22Make in CobraKJ  
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased		No		110	f	69.7105	0.0521	8			

**\*M6061T6R0 625\***

**\*\***

6061-T6 Round Bar .625"

Location

Loc Qty

Loc Code

MAT012

69.710474

m126726

1.854474

m1282654

19.856

\* m129167

48

7.375'

DAS

44  
9-89

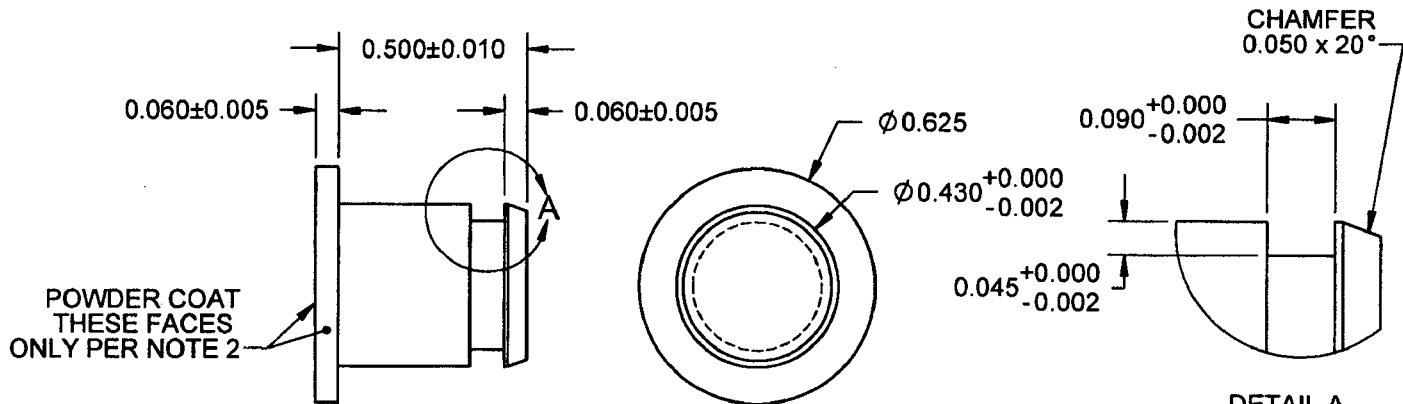
14/05/29.



**DART**

DESIGN <i>ff</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>ff</i>	DRAWING NO. <b>D2594</b>	REV. C SHEET 1 OF 1
DATE <b>06.11.20</b>		TITLE <b>PLUG</b>	SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28 *ff***D2594-1 PLUG****D2594-1 PLUG NOTES:**

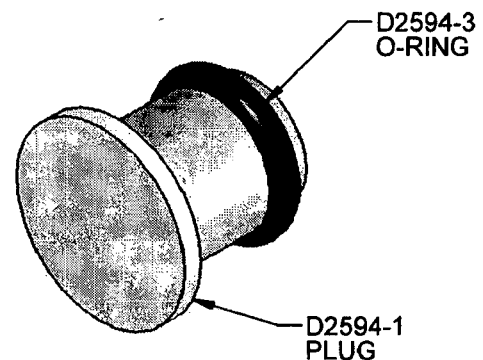
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3  $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011  $\triangle C$

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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